

Work Order ID 60066

June 24, 2010 8:58:09 AM

Page 1

Item ID: D3199-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 6/24/10

Start Qty: 30.00

Cust Item ID:

Required Date: 6/30/10

Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3199

100



Waterjet

FLOW CNC Waterjet

304 . 040

FLOW WATER JET

Memo

Cut as per Dwg D3199

Dwg Rev: E

Prog Rev: C

Deburr if required

0.00

0.00

1810-6-29

65

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

1810-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

81064/30

0.00

Memo

count
(465)

130



Small Fab

Small Fab

Small Fab

Memo

Form as per dwg D3199

0.00

SB 10/07/13

0.00

(65)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

81064/13

0.00

Memo

count
(465)

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Item Name: Bracket

Stop



Start Date: 6/24/10

Start Qty: 30.00



Cust Item ID:

Required Date: 6/30/10

Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M 112588

0.00

Memo

0.00

START TIME: 9:00

OVEN TEMPERATURE: 320°

FINISH TIME: 9:30

65 BR 10-7-15

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

JH

10/07/15

265 6

170



Packaging

Packaging

Identify as per dwg & Stock Location: 236A

0.00

Memo

0.00

Chap/15 (65)

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Start Qty: 30.00

Required Date: 6/30/10

Req'd Qty: 30.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

100A-15
MF
10-7-15

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June 24, 2010 8:58:08 AM

Page 1

Work Order ID: 60066

Parent Item: D3199-1

Parent Item Name: Bracket





Start Date: 6/24/10

Required Date: 6/30/10

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:C Removed Scribing 05-11-05 JLM
IPP Rev:D As per Rev B 06-11-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	69.9836	0.099	3.126316	6.5		
													

1810-6-29

Location

Loc Qty

Loc Code

MAT	66.1278
114574	66.1278
MAT20	3.8558
112885	2.7475
113062	1.1083

114574

65

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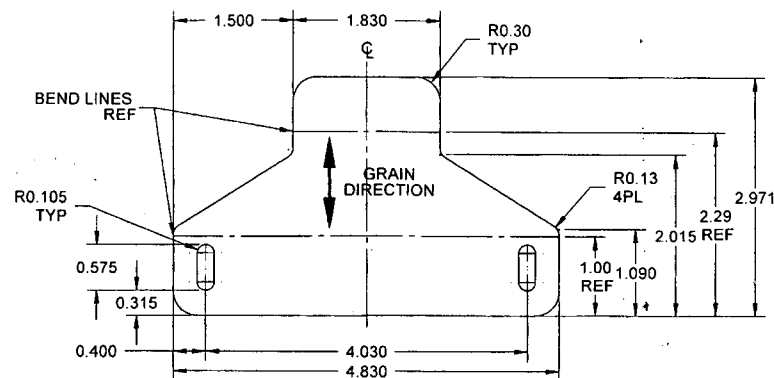
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No -DQA: _____ Date: _____

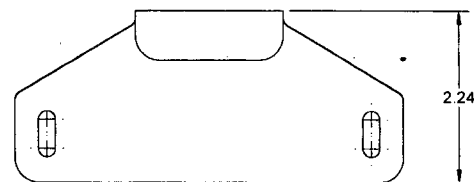
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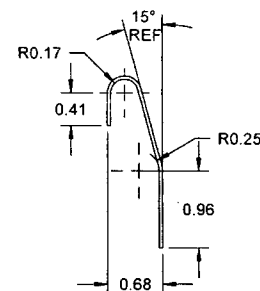
NOTE: Date & initial all entries



D3199-1F FLAT PATTERN



D3199-1 BRACKET
MADE FROM D3199-1F



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.11 lbs

C	ADD 3/4 PART (SHEET 2-4)	CB	09.11.19
B	2.24 WAS 2.142; ADD FINISH, UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.19		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3199	REV. C SHEET 1 OF 4
TITLE BRACKET	SCALE NTS
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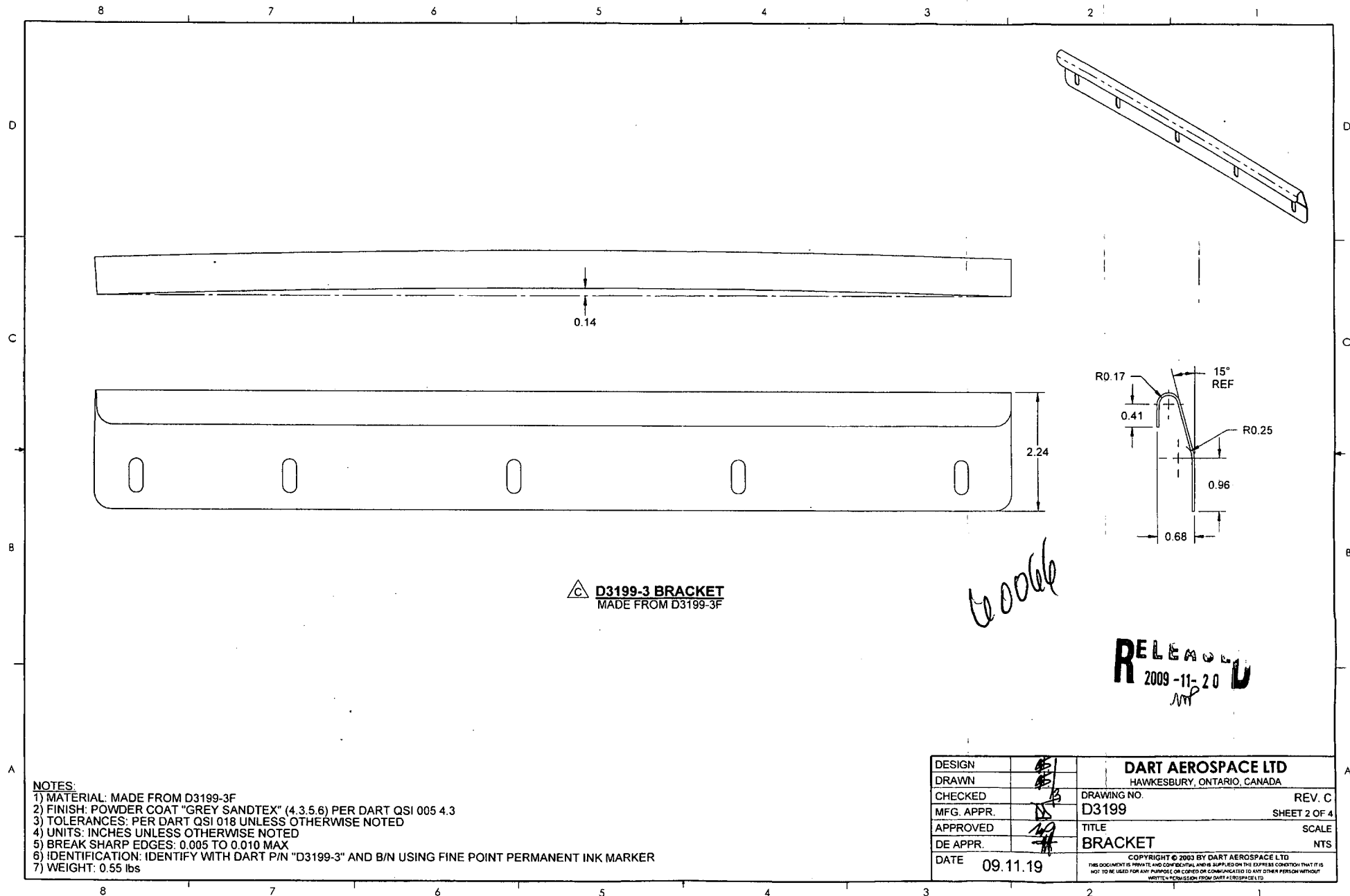
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



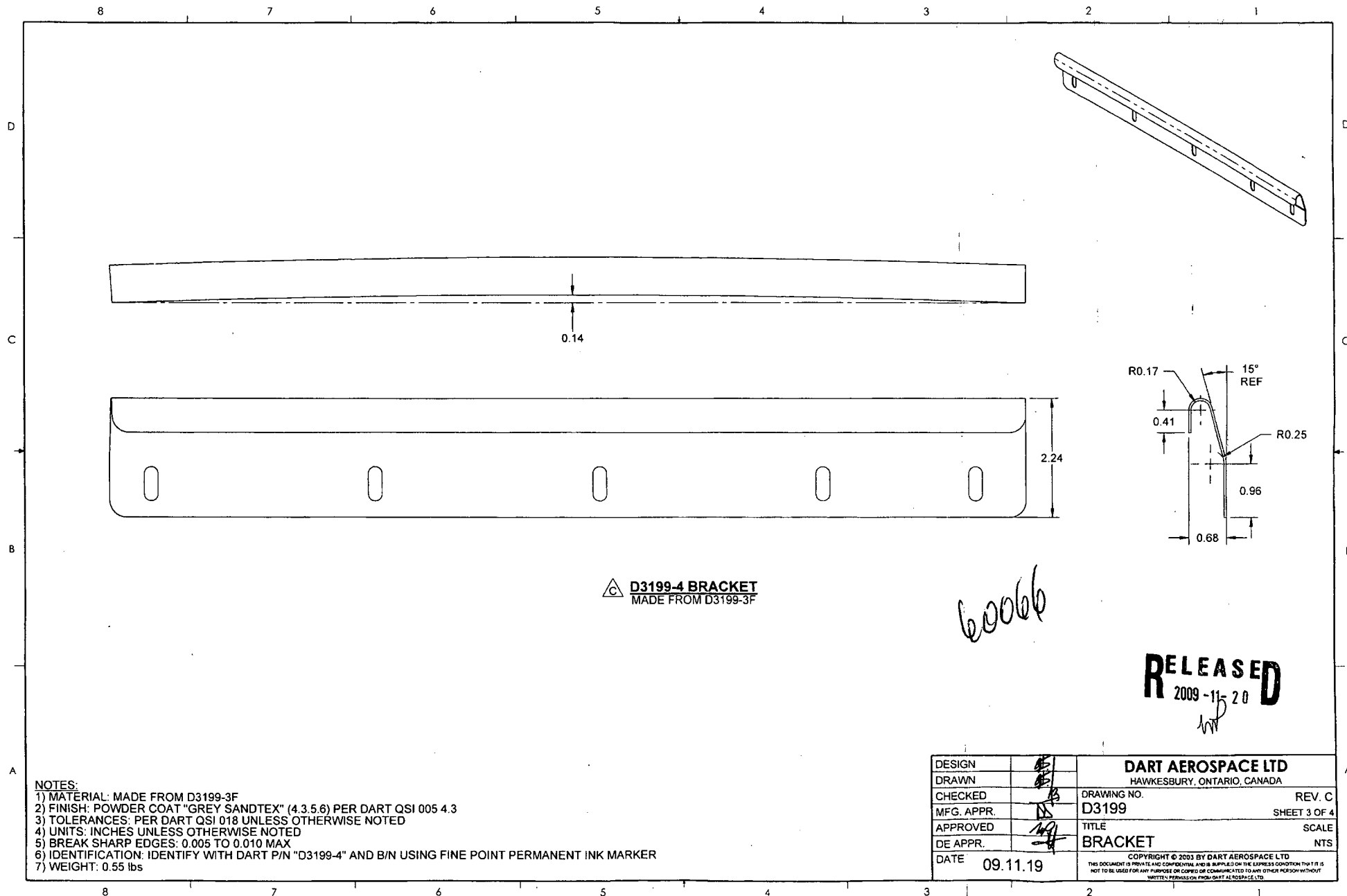
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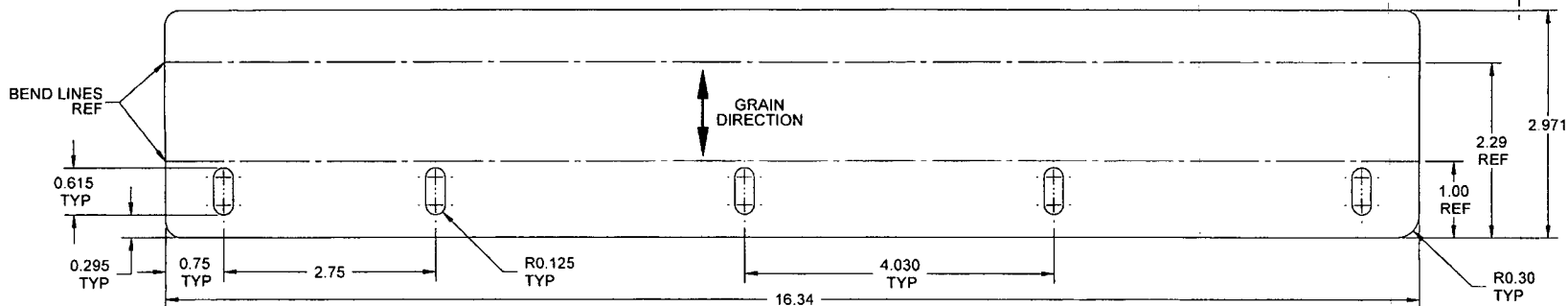
8 7 6 5 4 3 2 1

D

C

B

A



D3199-3F FLAT PATTERN

Woolf

RELEASED
2009-11-30
MB

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.55 lbs

DESIGN	<i>DE</i>	DART AEROSPACE LTD	
DRAWN	<i>DE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DE</i>	DRAWING NO. D3199	REV. C
MFG. APPR.	<i>DE</i>		SHEET 4 OF 4
APPROVED	<i>DE</i>	TITLE BRACKET	SCALE
DE APPR.	<i>DE</i>		NTS
DATE	09.11.19	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

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